



Cooling 

Tolerance -

Coating BetaUni Iron

Strategy **UNI**

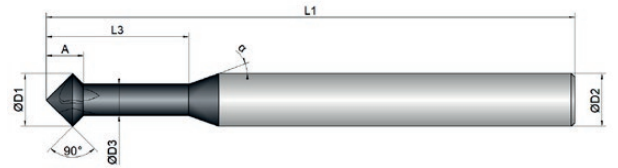
Application 

Features **HA**

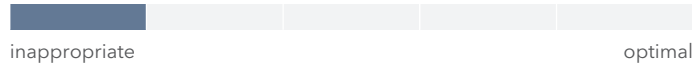
 Basic



- For universal chamfering of work pieces
- Forwards and backwards cutting


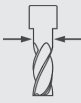
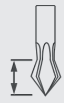


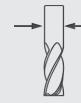




**Roughing**



**Finishing**



BCU1-M10-0023	D1  mm ∅	D3  mm ∅	A  mm	L3  mm	L1  mm	D2  mm ∅	z  #	α  °
3	3.0	2.2	2.0	10.0	50.0	4.0	4	20
4	4.0	2.9	2.5	10.0	50.0	4.0	4	20
5	5.0	3.9	3.0	15.0	65.0	6.0	4	20
6	6.0	3.9	4.0	15.0	65.0	6.0	4	20
8	8.0	5.9	2.5	20.0	70.0	8.0	4	20
10	10.0	5.9	4.0	23.0	72.0	10.0	4	20
12	12.0	5.9	6.0	23.0	73.0	12.0	4	20



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		Dimension	Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	Ø12			
		Infeed in mm	ae= 0.1xD	ae= 0.1xD	ae= 0.1xD	ae= 0.1xD	ae= 0.1xD	ae= 0.1xD	ae= 0.1xD			
		Application	ap= 0.1xD	ap= 0.1xD	ap= 0.1xD	ap= 0.1xD	ap= 0.1xD	ap= 0.1xD	ap= 0.1xD			
		Application										
Material	Strength (N/mm <sup>2</sup> )	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz			
<b>P</b>		<b>Vc (m/min)</b>										
1.1-1.3	Steel, unalloyed	<850	75	0.015	0.018	0.02	0.025	0.03	0.035	0.04		
2.1-2.2	Steel, low-alloyed	<950	55	0.012	0.016	0.018	0.023	0.028	0.033	0.038		
3.1-3.2	Steel, high-alloyed	<1100	40	0.01	0.014	0.015	0.02	0.025	0.03	0.035		
<b>K</b>		<b>Vc (m/min)</b>										
1.1-1.2	Grey cast iron	<1000	45	0.012	0.016	0.018	0.023	0.028	0.033	0.038		
<b>M</b>		<b>Vc (m/min)</b>										
1.1	Inox, ferritic/martensitic	<850	35	0.01	0.014	0.016	0.02	0.024	0.028	0.034		
2.1	Inox, austenitic	<650	30	0.008	0.012	0.014	0.018	0.022	0.026	0.032		
<b>N</b>		<b>Vc (m/min)</b>										
1.1-2.3	Alu, alloyed, casted	<600	150	0.02	0.023	0.025	0.03	0.035	0.04	0.045		
3.1-3.3	Cooper, alloyed	<600	80	0.012	0.014	0.015	0.02	0.025	0.03	0.035		
<b>T</b>		<b>Vc (m/min)</b>										
2.1-2.2	Titanium, pure, alloyed	<1000	30	0.008	0.012	0.014	0.018	0.022	0.026	0.032		
<b>S</b>		<b>Vc (m/min)</b>										
1.1-1.3	Super alloys	<1450	20	0.007	0.01	0.012	0.016	0.02	0.024	0.03		

**NOTE** | The values marked in turquoise are side applications!

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